

HEGGEL® Flex 595

High-Strength Castable Polyurethane Elastomer

You Build, We Protect!

Description:

HEGGEL Flex 595 is a two-component, flexible polyurethane-based casting resin designed to produce high-strength, rubber-like elastomers. It consists of a transparent Isocyanate and a yellowish transparent Polyol. It offers excellent flow properties for detailed casting and delivers high tear resistance and elongation.

Characteristics:

- Transparent and easy dyeable
- Very good flow properties
- Flexible
- High tear resistance
- Odourless
- Mercury-free

Application Areas:

HEGGEL Flex 595 is used for creating durable prototypes with rubber-like elasticity, manufacturing flexible components, and producing specialized jet masking templates.

Application Data:

Colour	Transparent
Mixing Ratio	A : B = 100 : 125 (Parts by weight)
Gel Time @ 20 °C	18 - 22 min (Measured for 200 g of mixture @ 20 °C)
Curing Time @ Room Temperature	6-10 hrs
Curing Time @ 70 °C	1-2 hrs

Technical Data:

Title	Standard	Value
Viscosity @ 25 °C	-	Mix: 2000 ± 200 mPa.s
		Com. A: 3250 ± 750 mPa.s
		Com. B: 230 ± 50 mPa.s
Density @ 20 °C	-	Mix: 1.05 ± 0.02 g/cm ³
		Com. A: 1.07 ± 0.02 g/cm ³
		Com. B: 1.05 ± 0.02 g/cm ³
Tensile Strength	ISO 37	7 ± 1 MPa
Tear Resistance	DIN ISO 34-1 (Arch shaped test piece without incision)	48 ± 3 kN/m
Elongation at Break	ISO 37	280 ± 30 %
Shore Hardness A	DIN ISO 7619-19	90 ± 3

Note: Values achieved in sampling are average values. Variation in product specification is possible.

Packaging:

Component A: 4 kg
Component B: 5 kg / 25 kg

Storage:

Shelf life has mentioned in the labels of each component. Original containers should be kept under dry and cool conditions between 18 - 25 °C. Tightly re-seal opened containers and use the content as soon as possible.

1. Surface Preparation

Porous mould surfaces shall be sealed prior to casting. The mould surface must be clean, dry, and free from contaminants.

2. Environmental Conditions

Material and working temperature must be kept between 18 °C – 25 °C.

3. Mixing

Measure the components according to the mixing ratio instruction and mix them thoroughly to get homogeneous mixture.

Mixing can be performed free from air bubbles by hand and in small quantities using a round stirring rod as well as in larger quantities by means of spiral stirrer.

The processing in a vacuum is also possible.

4. Application

Porous mould surfaces shall be sealed prior to casting using a suitable mould sealer, such as **HEGGEL Mould Sealer**.

To ensure proper demoulding, a suitable mould release agent, such as **HEGGEL Release Agent** is recommended, which can be applied by brush or spray. Perform the mould release 2-3 times, allowing approximately 20 minutes for evaporation after each application.

Close tightly containers immediately after use and use the content as soon as possible.

Note: To remove fresh contamination and to clean tools use **HEGGEL Cleaners**.

5. Safety Measures

The material safety data sheets of the individual components, the safety instructions on the packing (label) as well as the legal requirements for handling hazardous materials and waste disposal must be observed.

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